

sistant. He's Plant Superintendent E. F. Irwin. A score of years of experience are behind this man, most of them in toy making. He understands his products, his markets and, most of all, his young customers and adds a whimsical touch to many a product that phlegmatic adults might overlook.

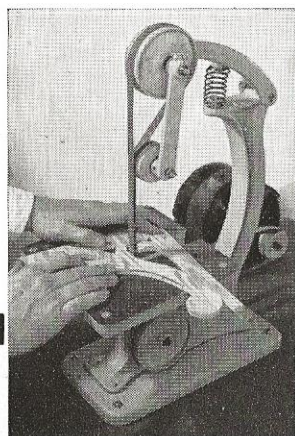
Under Mr. Irwin are some 120 employees in a 48,000 floor-foot plant and a 20,000 floor-foot shed space. Efforts are constantly made to keep production

as stabilized as possible. When it's between-season time, the workers cut dimension stock or prepare advance order products or assist in experimentation on new toys.

Woods used here are ponderosa pine, birch, magnolia, and a few others. The magnolia takes a beautiful lacquer finish and is hard enough to withstand breakage or splintering. The wood is inspected by the cutting department in the sheds before it is brought into the main plants. Swing and rip saws cut the wood to size and test it for internal flaws. The rough-cut wood is brought down to size in jointers, joiners, planers, and stickers. Table and band saws cut the stock to lengths and horizontal and drum sanders smooth off the rough spots.

Most of the blocks are of simple construction and require little intricate machining, but occasionally the shapers are needed. For this work automatic shaping machines are used at Play-skool. Routers and drills attend to all internal cuts. These run at high speeds, often 25,000 r.p.m. This high speed results in the smoothest possible internal finishes, leaving a nice surface without altering the reasonable dimensions and saving the difficult, time-absorbing internal sanding operations.

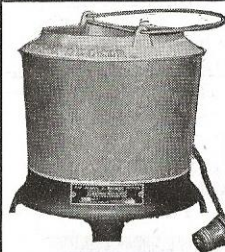
Drilling is often a major operation as in wheel-bearing toys such as miniature freight trains. Multiple drills are now being installed in the plant to ac-



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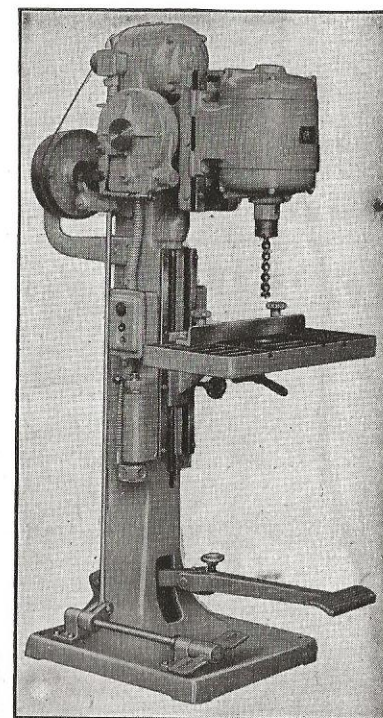
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